

# Work Order ID 57986

April 21, 2010 10:07:22 AM



Page 1

Item ID: D3641-1

Accept



Setup Start



Revision ID:

Item Name: Cover

Stop



Start Date: 21/04/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 28/04/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date: 10-4-21

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3641

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

1810-5-19

FLOW CNC Waterjet

1-Cut as per Dwg D3641

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

5052 . 032

(10)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

1810-5-19

Quality Control

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

8/2/19

(+10)

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 57986**

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Page 2

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Brake NC

NC BRAKE

Memo

0.00

0.00

SP 10/05/20

(10)

8

Brake NC

Form as per Dwg D3641-1

140



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

S 10/05/20

(10)

Quality Control

150



HandFinish

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

J 10/05/25

10

8

Hand Finishing

W/O:		WORK ORDER CHANGES					
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**Work Order ID 57986**

April 21, 2010 10:07:22 AM



Page 3

Item ID: D3641-1

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Setup Start



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Start Date: 21/04/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 28/04/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10 10-5-25

170

Identify as per dwg &amp; Stock Location: 260

0.00



Packaging

Memo

0.00

Packaging

10-5-26 10X SP

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/26  
CQ 10/5/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

April 21, 2010 10:07:26 AM

Page 1

Work Order ID: 57986

Parent Item: D3641-1

Parent Item Name: Cover



Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC  
IPP Rev:B ECN 1050 rev.b as per dwg 08-01-10 DD

Start Date: 21/04/2010

Required Date: 28/04/2010

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M5052H32S.032		Purchased	No			100	sf	76.0000	6.7259	325		
												
5052-H32 .032 Sheet												
<div>B10-5-19</div>												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT23	76	
100470	3	
103321	3	
105998	7	
108462	10	
109478	9	
111448	3	
112664	38	
15031	3	

112664

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	5798C
<b>Description: Cover</b>		<b>Part Number:</b>	D3641-1
<b>Inspection Dwg: D3641 Rev: B</b>		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.191	+0.005/-0.001	.194	✓			
0.191	+/-0.010	.194	✓			
0.37	+/-0.030	.374	✓			
0.54	+/-0.030	.544	✓			
0.69	+/-0.030	.693	✓			
11.86	+/-0.030	11.86	✓			
12.22	+/-0.030	12.22	✓			
23.37	+/-0.030	23.37	✓			
23.54	+/-0.030	23.54	✓			
23.69	+/-0.030	23.69	✓			
24.06	+/-0.030	24.06	✓			
0.50	+/-0.030	.500	✓			
4.28	+/-0.030	4.281	✓			
4.78	+/-0.030	4.782	✓			
0.032	+/-0.010	.030	✓			

<b>Measured by:</b>	DB	<b>Audited by:</b>	S	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	10-5-19	<b>Date:</b>	10/05/19	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	AA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

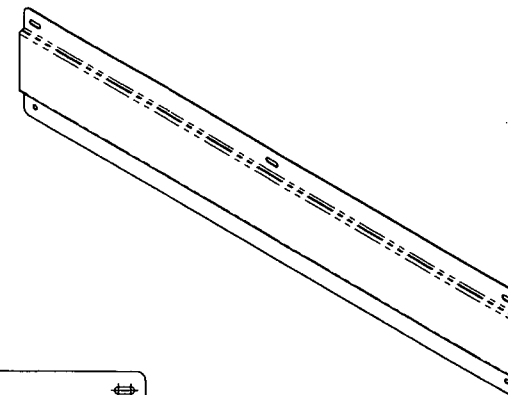
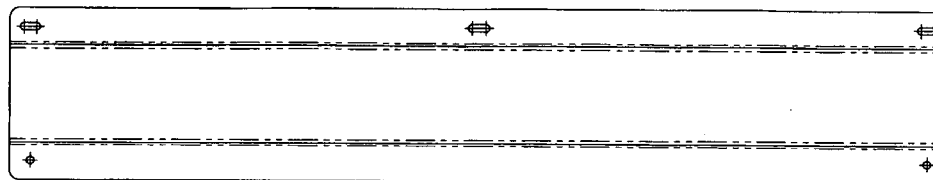
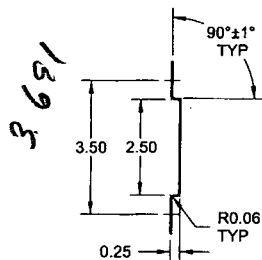
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 57984  
*BS 10-4-21*



**D3641-1 COVER**  
**(REPLACES GENEVA P/N G10606-3/-6)**  
 (MAKE FROM D3641-1F FLAT PATTERN)

**RELEASED**  
 2009-11-18  
*MP*

**NOTES:**

- 1) MATERIAL: D3641-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.35 lbs

C	REFORMAT DRAWING TO CURRENT STANDARDS; D3641-3 WAS 4 (ZN C4-2); ADD D3641-4 VIEW (ZN A4-2); MOVE -1F/-3F FLAT PATTERN TO SHEET 3. PER NCR 09-076	RF	09.10.02
B	UPDATE PROFILE TO MATCH TOOLING; GENERAL UPDATE	LE	07.10.16
A	NEW ISSUE; REPLACES G10606	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3641	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	COVER	NTS
DATE	09.10.02	<small>COPYRIGHT © 2007 BY DART AEROSPACE USA, INC.          THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS          NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT          WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

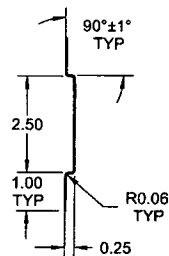
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

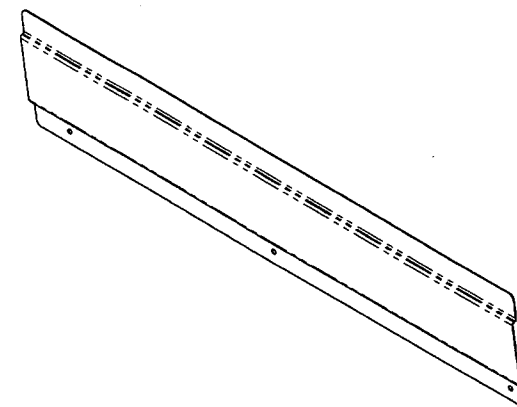
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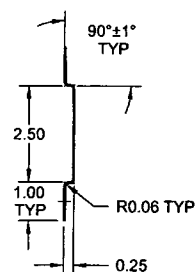


**D3641-3 COVER**  
**(REPLACES GENEVA P/N G10606-5)**   
 (MAKE FROM D3641-3F FLAT PATTERN)



**D3641-3 COVER (SHOWN)**  
**D3641-4 COVER (OPPOSITE)**

*W/057986*



**D3641-4 COVER**  
**(REPLACES GENEVA P/N G10606-4)**   
 (MAKE FROM D3641-3F FLAT PATTERN)

**RELEASED**  
 2009-11-10  
*W/057986*

**NOTES:**

- 1) MATERIAL: D3641-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-3/-4" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.36 lbs

DESIGN	TS	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3641	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		COVER	NTS
DATE	09.10.02	<small>COPYRIGHT © 2007 BY DART AEROSPACE USA, INC.          THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS          NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT          WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

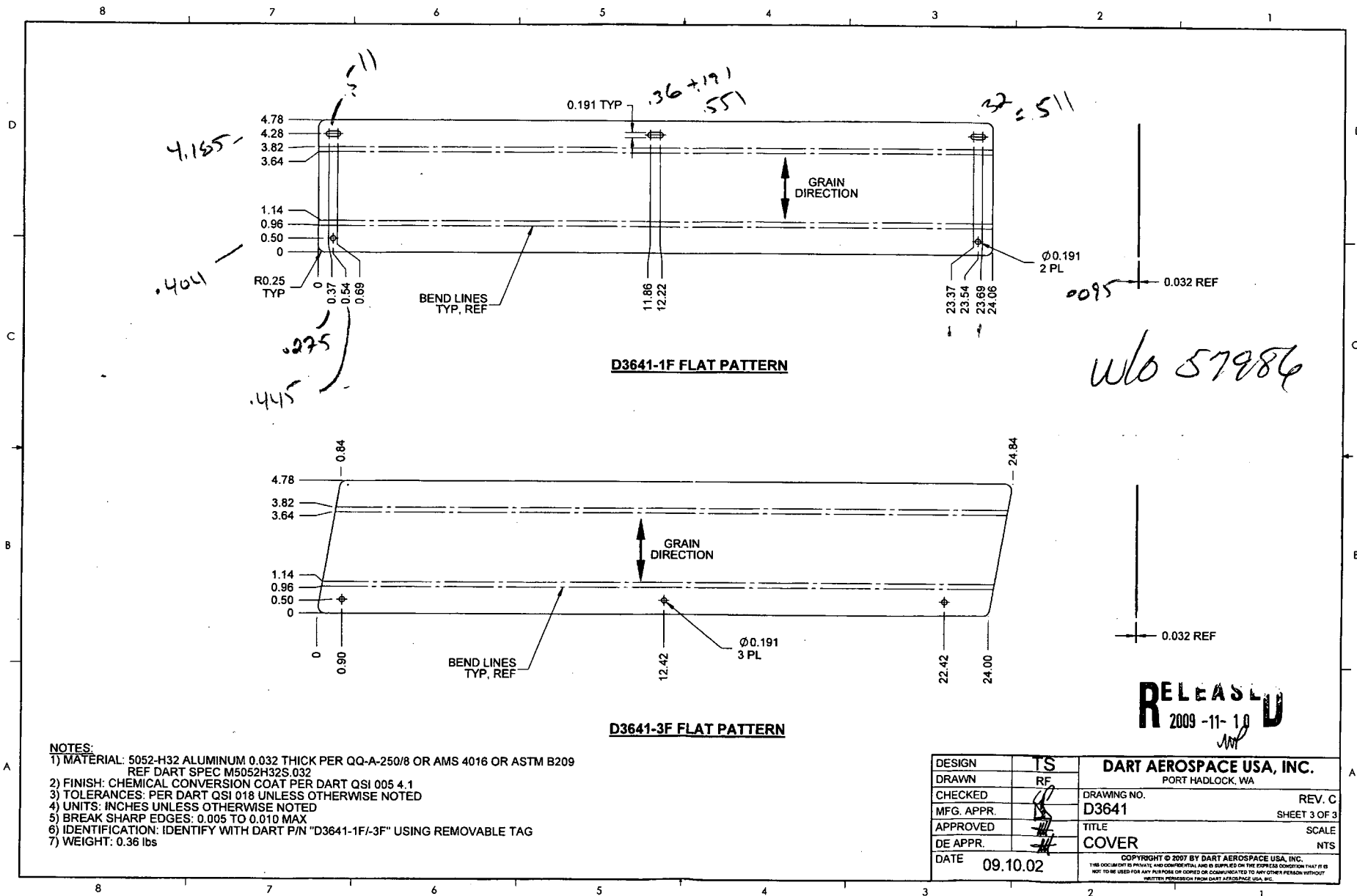
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